

Date: Tuesday, 06/01/2009 10:04:48 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
 Job Number : 44399
 Estimate Number : 11111
 P.O. Number :
 This Issue : 06/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D33048
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D3304 REV B
 Previous Run : 40908 Project Number : N/A
 Material :
 Due Date : 20/01/2009 Qty: 20 Um: Each
 Written By :
 Checked & Approved By : JUL 09.01.06
 Comment : Est A 04.09.07 New issue KJ/JLM
 Est B 08.08.06 waterjet EC verified by: DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S20GA 304/316 .040 Sheet



Comment: Qty.: 0.0683 sf(s)/Unit Total : 1.3650 sf(s)

304/316 .040 Sheet

batch: 110076 HB 9-2-23

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3304

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

HB 9-2-23

M-1 09/02/23

(21)

(21X)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 9-2-23

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 02/08/23 counter (720)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D3304

SP 09/03/09

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 06/01/2009 10:04:49 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 44399

Part Number: D33048

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



2090310 (21)



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Carl L*

SS 09/03/10 x21

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/10 JG

Job Completion



*mf
09-03-10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44399
Description: Bracket		Part Number: D3304-8
Inspection Dwg: D3304	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.131	✓			
Ø0.219	+0.005/-0.001	.222	✗			
0.375	+/-0.010	.375	✓			
0.500	+/-0.010	.502	✓			
1.500	+/-0.010	1.499	✗			
0.375	+/-0.010	.377	✓			
0.937	+/-0.010	.938	✗			
2.000	+/-0.010	2.005	✗			
0.375	+/-0.010	.373	✗			
2.250	+/-0.010	2.254	✗			
3.875	+/-0.010	3.871	✗			
1.000	+/-0.010	1.004	✗			
1.125	+/-0.010	1.127	✗			
.040	+/- .010	.040	✗			

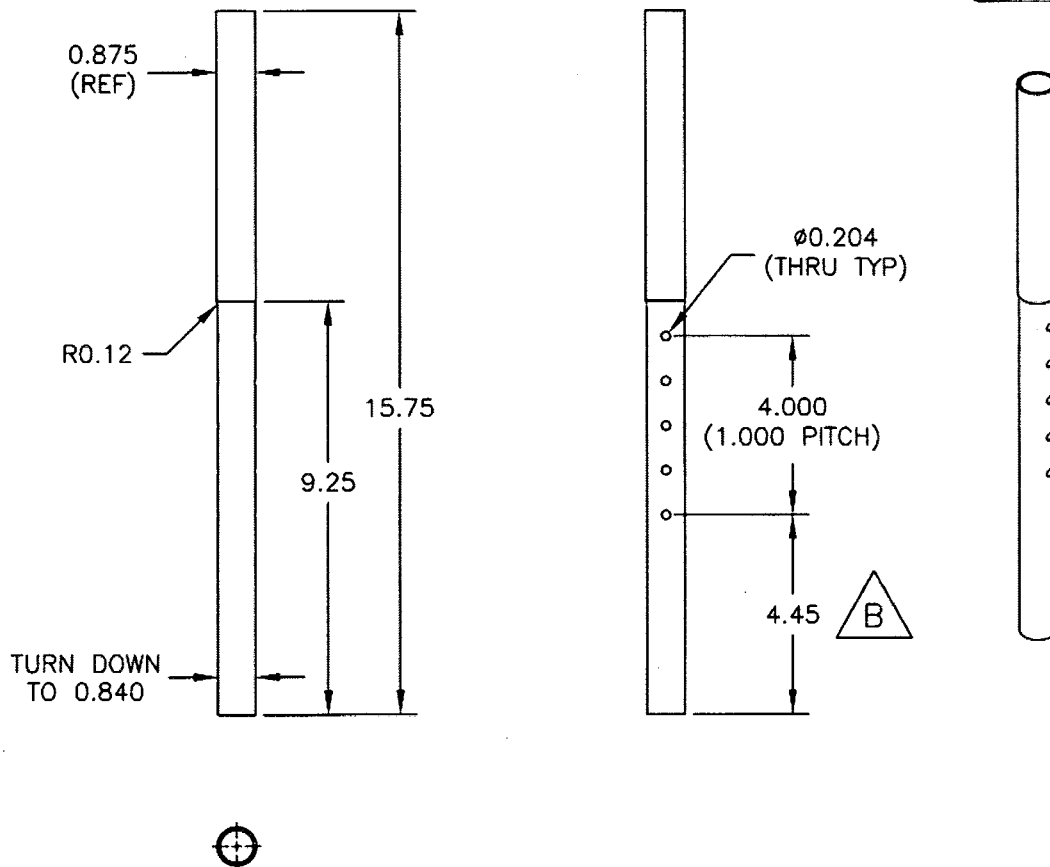
Measured by: <i>B</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: 9-2-23	Date: 09/02/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	<i>[Signature]</i>



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. B SHEET 2 OF 4
DATE 05.07.15	TITLE TUBE ASSEMBLY		SCALE 1:4

RELEASED
05-08-11 *[Signature]*



D3304-1 TUBE

D3304-1 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED WITHOUT NOTICE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

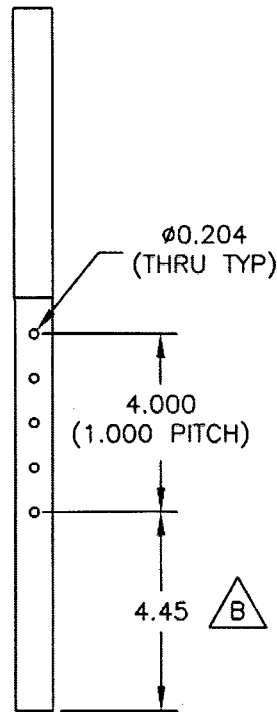
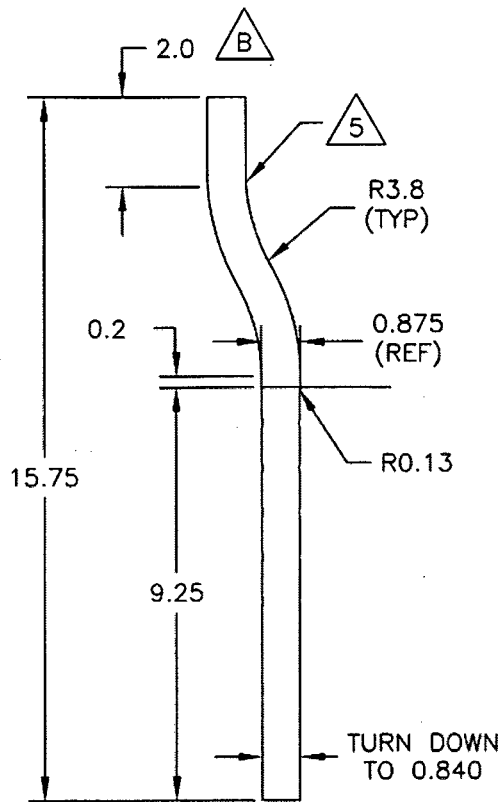
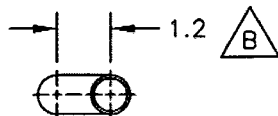
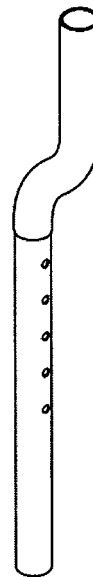
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WORK ORDER
NO. *44399*

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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. B SHEET 3 OF 4
DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4

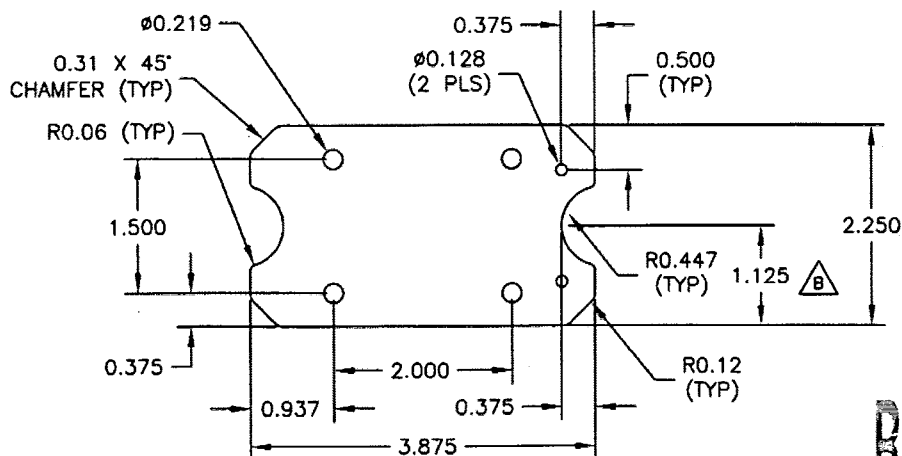
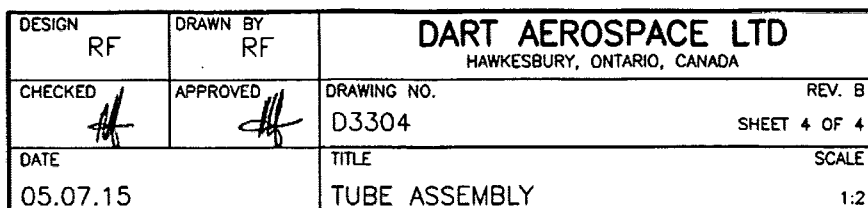
**RELEASED**
05-08-11 *[Signature]***D3304-3 TUBE****D3304-3 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL
(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) BEND LINES 9.625, 13.375 DIMENSIONS

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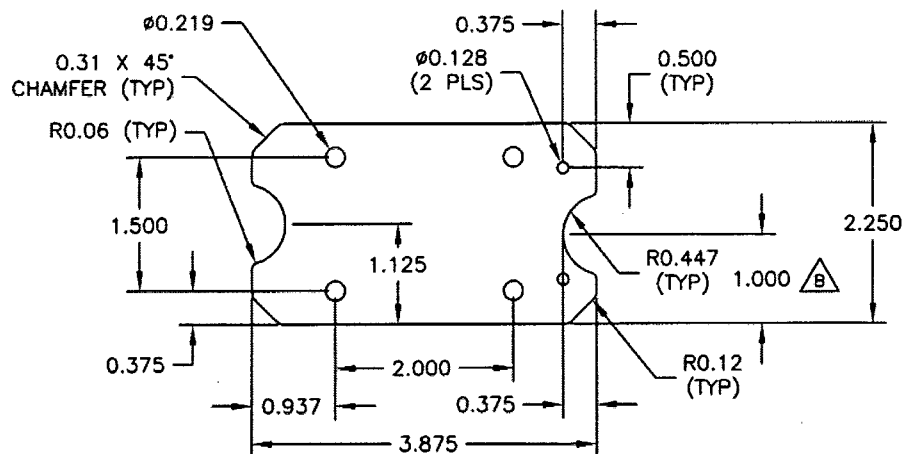
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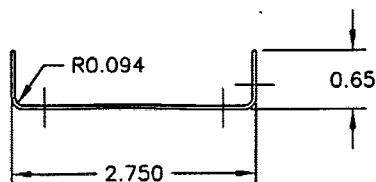


D3304-5 FLAT PATTERN


RELEASE
05-08-11



D3304-7/-8 FLAT PATTERN



D3304-5/-7 BRACKET
D3304-8 OPPOSITE

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 (GA) WORK ORDER

N. 4439

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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